

Work Order ID 51723

August 28, 2009 2:58:38 PM



Page 1

Item ID: D3140-95

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 8/31/09 Start Qty: 6.00



Cust Item ID:

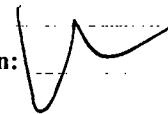
Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3140	Rev F

110



Small Fab

0.00

6 0

Small Fab

Memo

0.00

PULL FROM STOCK:

6 X D3140-95 B
~~34375~~ (WERE NOT BENT)

1-Scuff surfaces with 80grit sandpaper per QSI 006-2-Deburr.|| No sharp edges

SB09/08/31

120



NC BRAKE

0.00

8 09/08/31

Brake NC

Memo

0.00

6 0

Brake NC

Bend as per Dwg D3140

130



QC5- Inspect part completeness to step on W/O

0.00

=> SB09/08/31

QC

Memo

0.00

(x6) 0

Quality Control

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Page 2

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Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

140



HandFinish

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Hand Finishing

Memo

0.00

BK 09-08-31 (6).

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

09/08/31

(6)

φ

160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

9/8/31 (6) SP

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Page 3

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Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 8/31/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/09

Quality Control

PL 0991

Picklist Print

August 28, 2009 2:59:49 PM

Page 1

Work Order ID: 51723



Parent Item: D3140-95RevF



Parent Item Name: Doubler

Start Date: 8/31/09

Required Date: 9/04/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3140-95RevF		Manufactured	No				Each	9.0000	6.0000			

Doubler



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

34375

9

9

809107/31

46

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3140	
DATE 06.10.06		REV. F SHEET 1 OF 7	
		TITLE DOOR	
		SCALE NTS	
A 02.04.18		NEW ISSUE	
B 03.01.23		REMOVE -65/-81/-83; ADD -301/-303	
C 04.11.08		CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D 05.11.23		ADD -103/-104/-105/-106; REMOVE -67	
E 06.06.09		1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F 06.10.06		ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.03

WJS/123

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
			1	X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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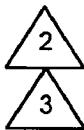
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CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06	TITLE DOOR		SCALE NTS



1 COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



2 FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3 MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

5/11/03

RELEASED

06.11.13



4 MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



5 MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



6 MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



7 MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



8 ALL DIMENSIONS IN INCHES



9 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



10 MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



11 DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



12 DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



13 RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

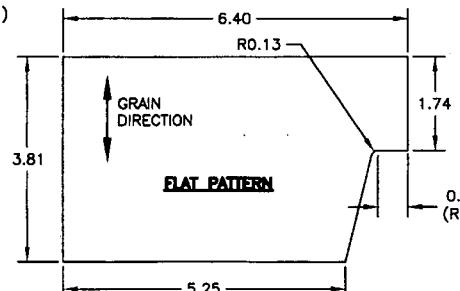
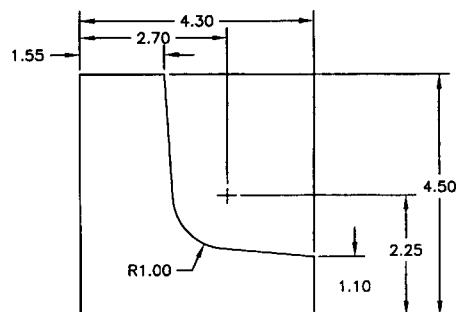
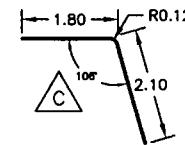
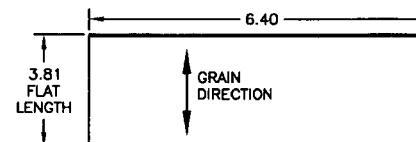
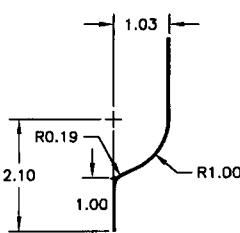
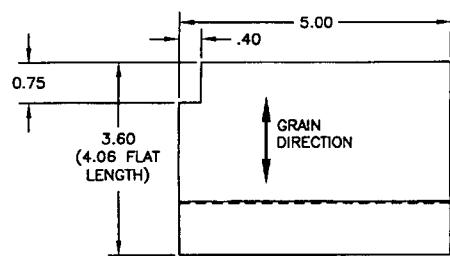
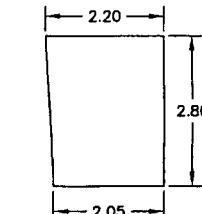
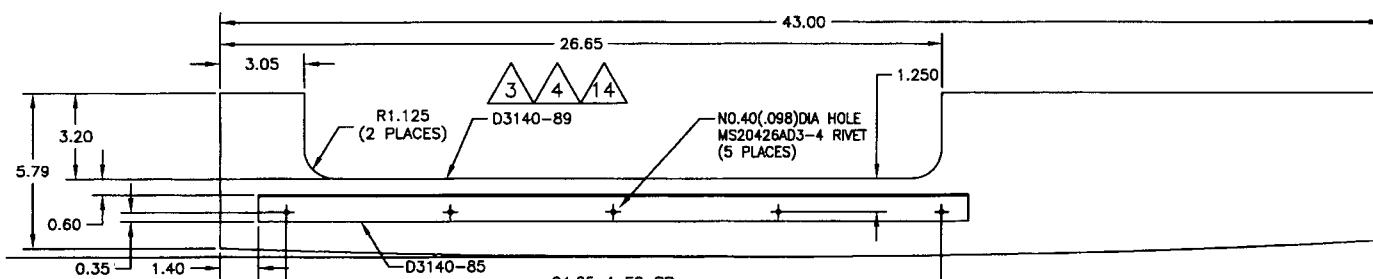


14 PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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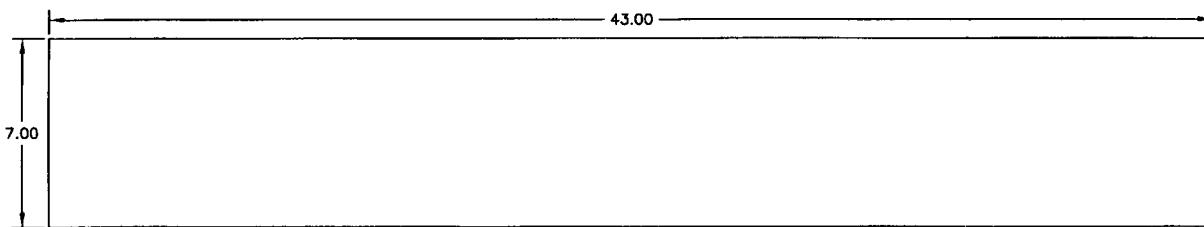
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S1723
06.11.13

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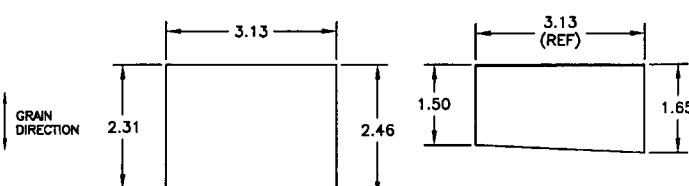
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4	CB	DART
CHECKED	APPROVED	DRAWING NO.
06.10.06		D3140
DATE	TITLE	SCALE
	DOOR	NTS

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

REV. F
SHEET 5 OF 7
SCALE
NTS



D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

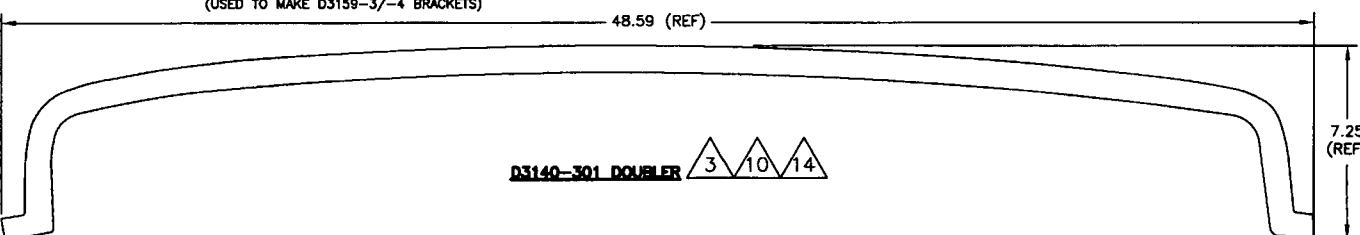
D3140-105 DOUBLER
D3140-106 OPPOSITE 4 14 D



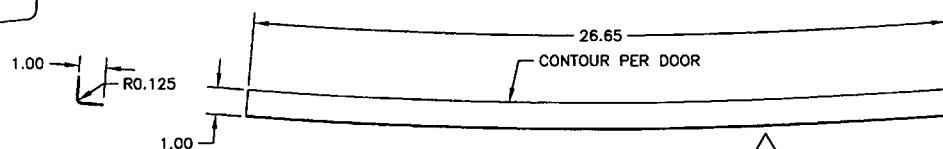
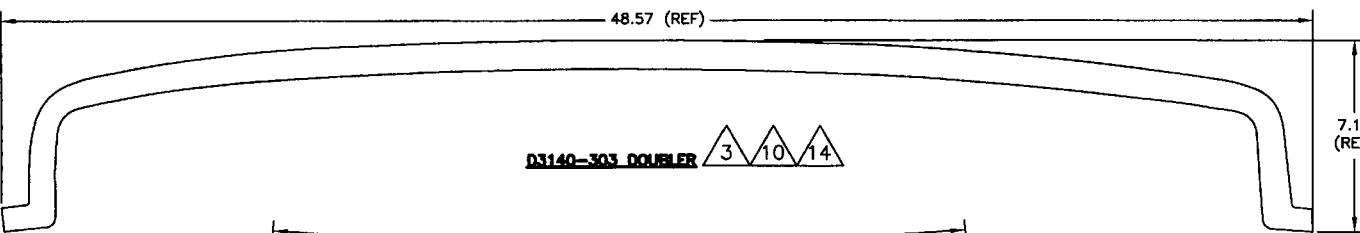
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

D3140-104 DOUBLER
D3140-103 OPPOSITE 4 14 D F

4 14 D F



51723
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06/11/03

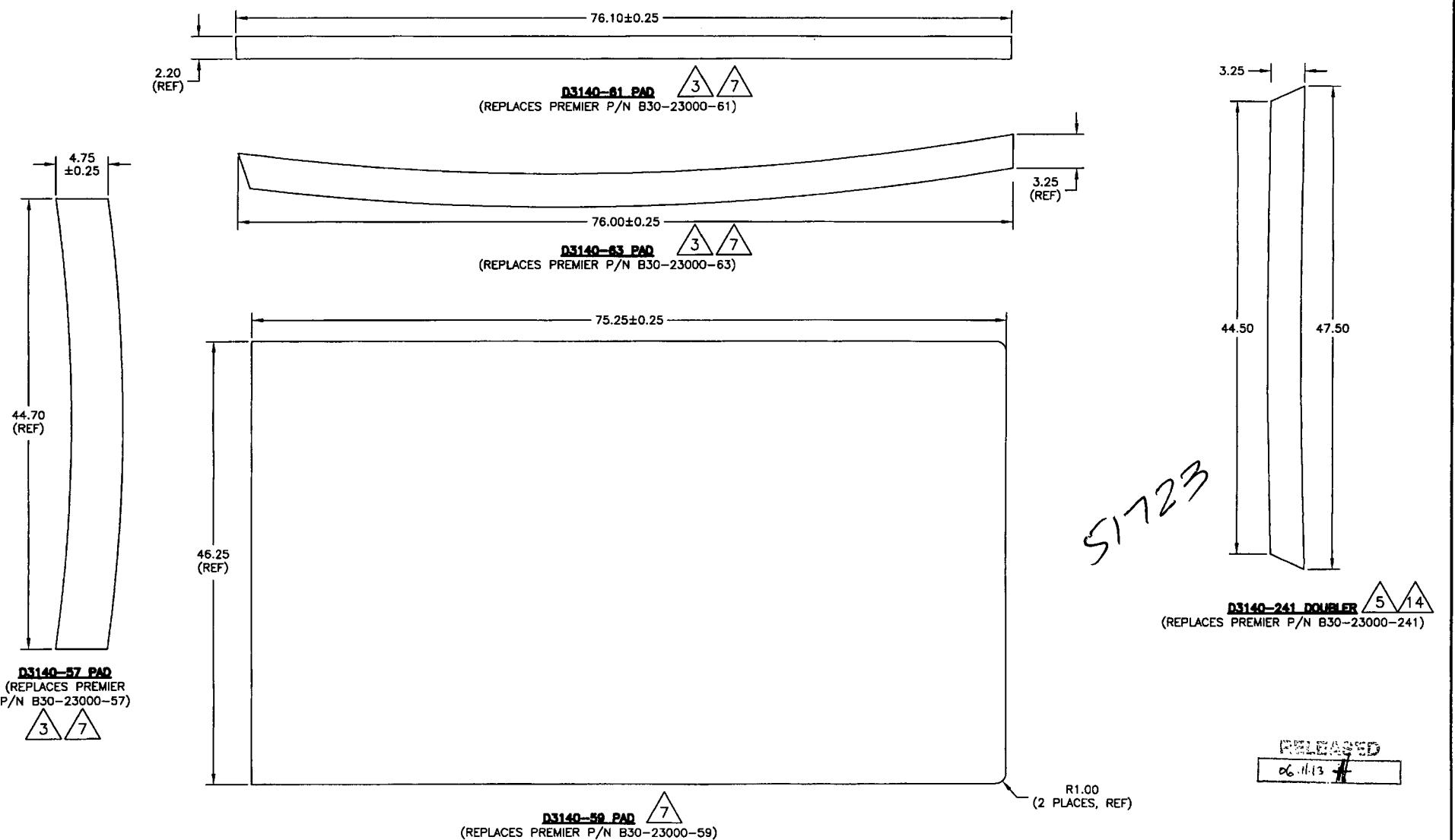


D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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DATE 06.10.06		TITLE DOOR	SCALE NTS



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DATE	06.10.06	TITLE	DOOR	SCALE NTS	